

# Work Order ID 63867

November 17, 2010 11:53:09 AM

Page 1

Item ID: DSI 9396-011

Accept

Revision ID:

Item Name: Fwd Crosstube Support Change

Start Date: 11/17/10 Start Qty: 2.00

Required Date: 11/17/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9396

Rev B

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels as per PPP DSI 9396 CHIG001

8/10/17

10-11-17  
(2)

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/10/17

(+2)

120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP DSI 9396

Location: \_\_\_\_\_ PPP Rev: A

pick list

8/10/17 (2)

8/10/17 (2)

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Item ID: DSI 9396-011

Accept



Setup Start



Revision ID:

Item Name: Fwd Crosstube Support Change

Stop



Start Date: 11/17/10 Start Qty: 2.00



Cust Item ID:

Required Date: 11/17/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/17 AJ

MF  
10-11-17

# Picklist Print

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Page 1

Work Order ID: 63867

Parent Item: DSI 9396-011

Parent Item Name: Fwd Crosstube Support Change



Start Date: 11/17/10

Required Date: 11/17/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-12-17 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3595-063-450		Manufactured	No			110	Each	58.9990	4	8			

SA RUBBER CUSHION

Location	Loc Qty	Loc Code
LG	58.99897368	
53775	5.97897368	
58161	3.56	
59580	0.12	
61465	29.34	
62535	20	

MS21920-25

Purchased No

110 Each 107.0000 4

SA Clamp(per MIL-DTL-8783C)

Location	Loc Qty	Loc Code
LG	83	
113281	0	
114759	5	
114901	3	
115278	25	
115849	50	
ST451	24	
113281	5	
113282	18	
113744	1	

61465

115278

11/17/10

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-594 Rev. C (AND EARLIER) AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-594 Rev. 2 (AND EARLIER)  
REF. CANADIAN STC: SH03-6  
REF. FAA STC: SR01742NY

REFERENCE ONLY

For D205-596-101/-103 Crosstubes (ref. 39" Landing Gear) or D205-596-105/-107 Crosstubes (ref. 31" Landing Gear) at CHG 002 or later, the D2856-600-851/-1009 Abrasion Strips have been removed, the MS21920-25 Clamp replaces the MS21920-24 Clamps, the D2893-1 and D2940-1 Supports have been bonded onto the crosstubes using Magnobond 6398 and D3595-063-450/-530 Rubber Cushions have been installed underneath the MS21920-25/-28 Clamps. Amend Parts List of IIN-D205-594 Section 5 and ICA-D205-594 Section 32.8 as follows:

## Remove:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
2		2		D2856-600-851	ABRASION STRIP
	2		2	D2856-600-1009	ABRASION STRIP
4		4		MS21920-24	CLAMPS

## Add:

QTY -101	QTY -103	QTY -105	QTY -107	Part Number	Description
4		4		D3595-063-450	RUBBER CUSHION
	4		4	D3595-063-530	RUBBER CUSHION
4		4		MS21920-25	CLAMP

To prevent the supports from shifting on D205-596-101/-103/-105/-107 Crosstubes at CHG 001, the D2893-1 or D2940-1 Supports should be removed and re-installed as follows:

- 1) Follow section 32.1 of ICA-D205-594 for the removal of the crosstubes from the helicopter.
- 2) Remove the MS21920-24/-28 Clamps that fasten the D2893-1 and D2940-1 Supports from the crosstubes per Section 32.3 of ICA-D205-594.
- 3) Remove the D2856-600-851/-1009 Abrasion Strips from the crosstube per section 32.5 of ICA-D205-594.
- 4) Inspect the crosstube surface underneath the supports for corrosion and mechanical damage per items 5.3.1 and 5.3.2 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.3 of the 300 hour inspection.
- 5) Inspect the supports for corrosion and mechanical damage per items 5.3.4 of the 300 hour inspection. Repair damage within acceptable limits and touch up finish per item 5.3.4 of the 300 hour inspection.
- 6) Abrade area to which support will be applied with 400 grit sandpaper. Saturate a clean cloth with MEK or 4105S Wash'n'Wipe Degreaser or equivalent and wipe area until there is no residue.
- 7) Apply a 0.03" to 0.06" thick layer of Magnobond 6398 underneath D2893-1 or D2940-1 Supports and re-install the Supports on the crosstube as shown in Figure 1. Install a D3595-063-450/-530 Rubber Cushion on each MS21920-25/-28 Clamp. Position and secure the D2893-1 or D2940-1 Supports on the crosstube using MS21920-25/-28 Clamps. Torque clamps to 80-100 in-lb. Let the D205-596-101/-103/-105/-107 Crosstube Assembly cure before re-installing the crosstube on the aircraft.

**Note:** It is acceptable to substitute the MS21920-25/-28 with longer or shorter clamps to accommodate varying diameters. Ensure there is a minimum of 1.5 threads in safety on the nut.

- 8) Re-install the D205-596-101/-103/-105/-107 crosstube per section 32.2 of ICA-D205-594.

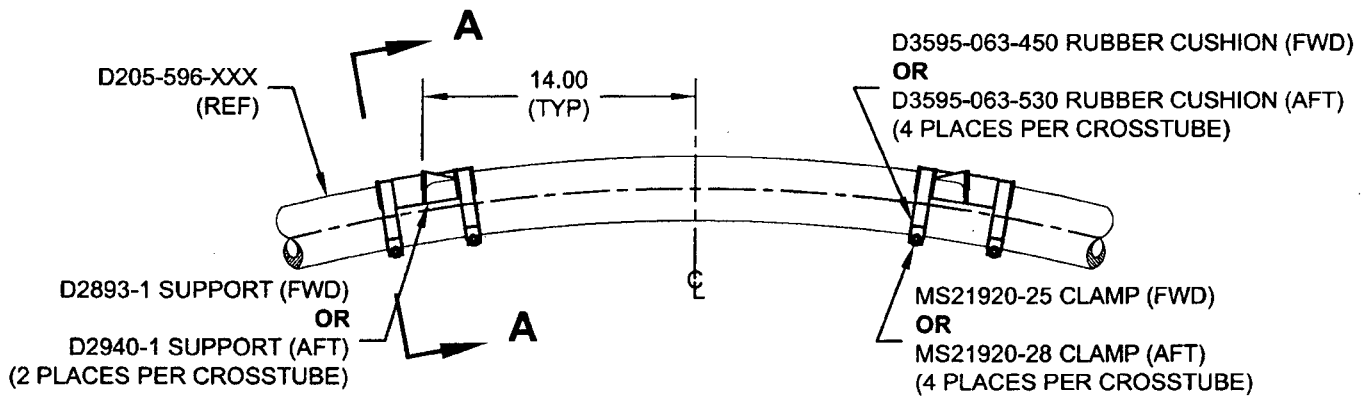
CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY: <i>[Signature]</i>	D. SHEPHERD (DE # 02)
DATE: 07.12.04	
CERT. NO.: SH03-6	
ISSUE NO.: 3	

B	REPLACE MS21920-24 WITH MS21920-25 ON -101/-105; ADDED EXTRA NOTE TO INSTALLATION PROCEDURE (STEP 7)	MB	07.12.04
A	NEW ISSUE	MB	07.11.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	DSI 9396	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CROSSTUBE SUPPORT CHANGE	NTS
DATE	07.12.04	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

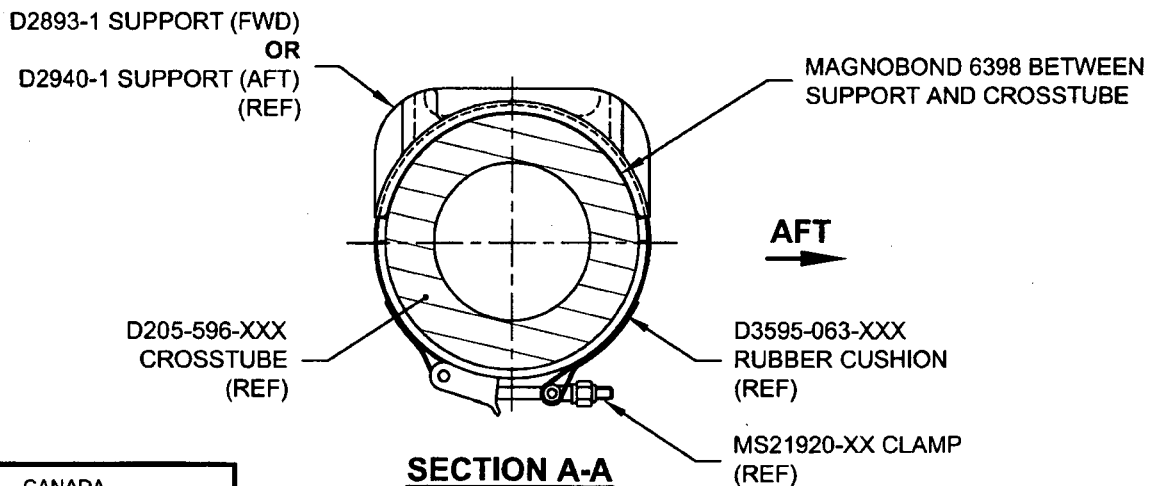
For customers who would like to upgrade their D205-596-101/-103/-105/-107 Crosstubes from CHG 001 to CHG 002, the following kits can be obtained from Dart:

### DSI 9396-XXX PARTS LIST

QTY -011	QTY -013	Part Number	Description	REFERENCE ONLY
X		DSI 9396-011	FWD CROSSTUBE SUPPORT CHANGE (D205-596-101/-105 FWD CROSSTUBE)	
	X	DSI 9396-013	AFT CROSSTUBE SUPPORT CHANGE (D205-596-103/-107 AFT CROSSTUBE)	
4		D3595-063-450	RUBBER CUSHION	
4		MS21920-25	CLAMP	
	4	D3595-063-530	RUBBER CUSHION	
	4	MS21920-28	CLAMP	



**FIGURE 1: INSTALLATION OF SUPPORT ON CROSSTUBE**









### SECTION A-A

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 07.12.04  
CERT. NO.: SH03-6  
ISSUE NO.: 3

DESIGN		<b>DART AEROSPACE LTD</b> <b>HAWKESBURY, ONTARIO, CANADA</b>	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9396	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CROSSTUBE SUPPORT CHANGE	NTS
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